

Date: Monday, 3/13/2006 7:30:14 AM
User: Kim Johnston

Process Sheet

split
SP 06/06/14

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY
Job Number : 26211
Estimate Number : 10385
P.O. Number : *NIA* Part Number : D3065041
This Issue : 3/13/2006 S.O. No. : *NIA* Drawing Number : D3065 REV A2
Prsht Rev. : NC Project Number : N/A
First Issue : *NIA* Type : SMALL /MED FAB Drawing Revision : A2
Previous Run : 24408 Material : *NIA*
Written By : *See COMMENT Below* Due Date : 3/30/2006 Qty: 60 Um: Each
Checked & Approved By : *06.03.13 N*
Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 26211A STEP SPACER



Comment: Sub-Component STEP SPACER

2.0 26211B STEP SPACER



Comment: Sub-Component STEP SPACER

3.0 26211C STEP LEG



Comment: Sub-Component STEP LEG

4.0 26211D STEP SPACER



Comment: Sub-Component STEP SPACER

5.0 D30651 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
Step Spacer

Pick:

Qty Part Number
1 D3065-1

Description
Spacer

Batch

B26211A

① B26422A

6.0 D30653 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
Step Spacer

Pick:

Qty Part Number
1 D3065-3

Description
Spacer

Batch

B26211B





SP 06/06/14

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/06/12	10	Part D3065-1, D3065-3 & D3065-7 have to be redrill hole at .120 hole to be at .128		drill	SB 06/06/12			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 26211

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D30655

Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Leg

Pick:

Qty Part Number

Description

Batch

2 D3065-5

Leg

B26211C (3) B23618

8.0

D30657

Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Spacer

Pick:

Qty Part Number

Description

Batch

1 D3065-7

Spacer

B30126928D

9.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number

Description

Batch

30 MS20470AD4-4

Rivet

m1829

SB 04/06/19 (46)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

SB 06/06/19 PT (46)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06-06-19 46

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W4 17, 19, 20

SB 06-06-21

45

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 26211

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



(45)

Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/06/21

Job Completion



le de do 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

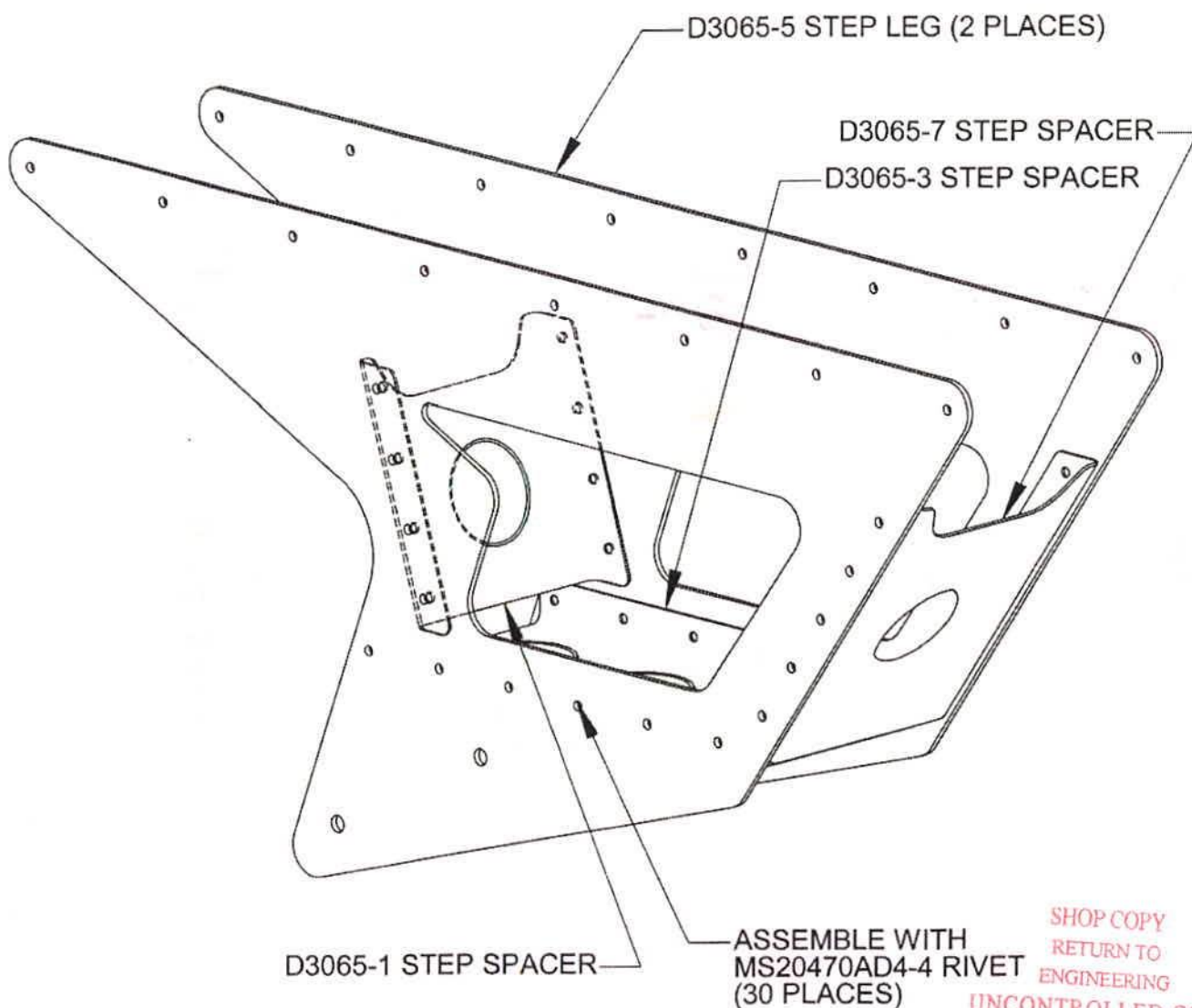
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>CP</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>	0.551 WAS 0.410	

RELEASED
02.09.20 *#*



D3065-041 STEP LEG ASSEMBLY

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NO. 26211

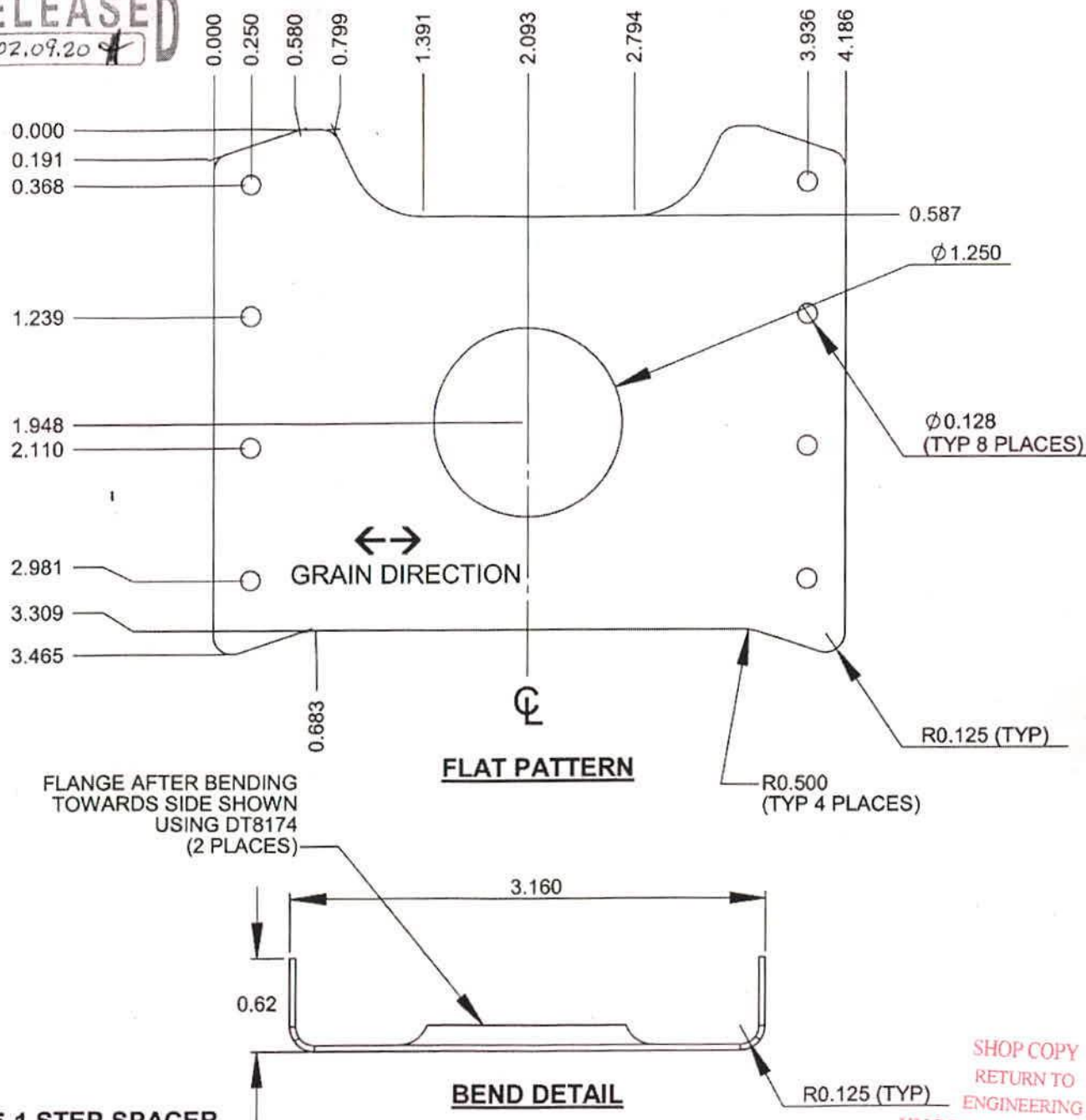
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *[Signature]*



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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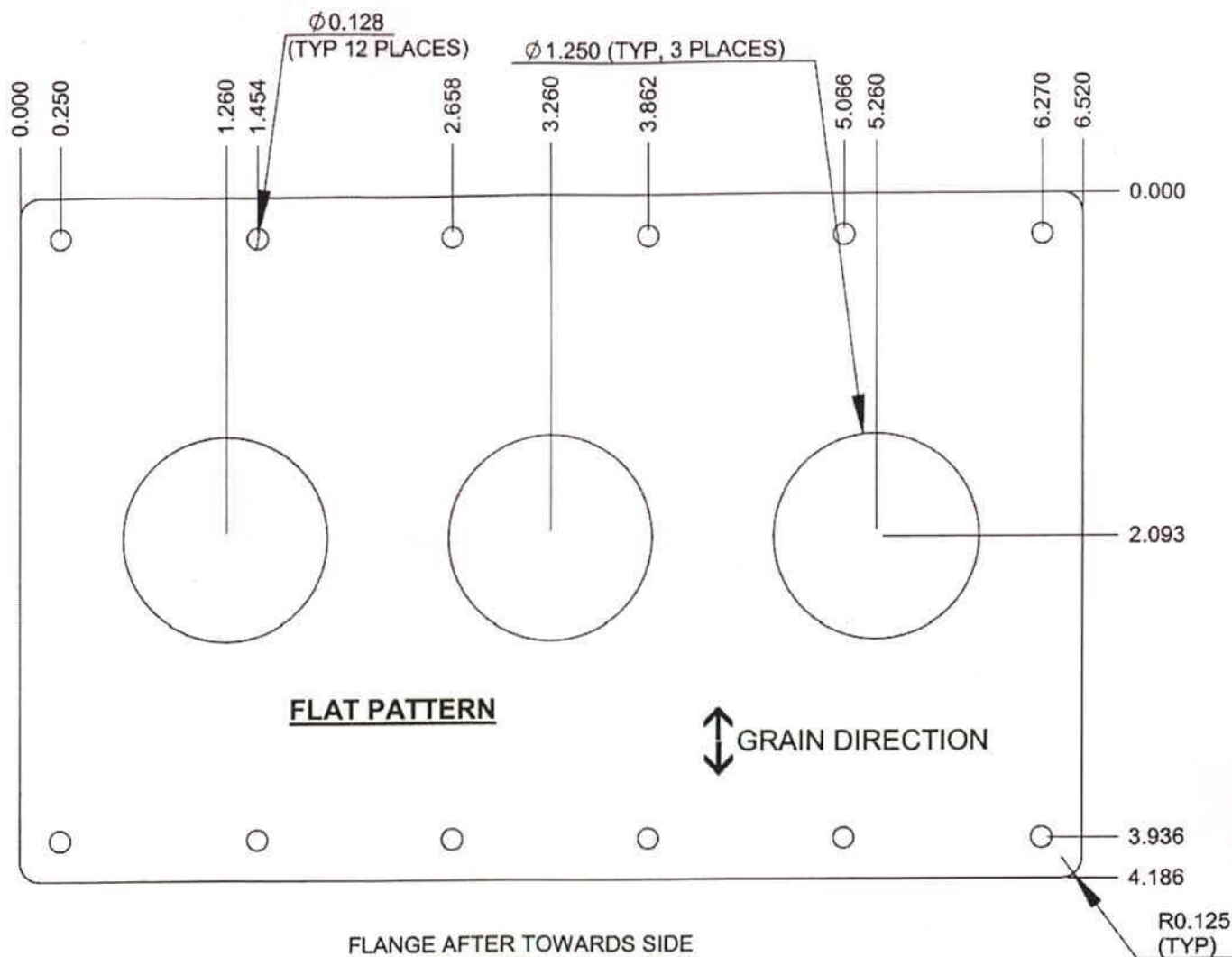
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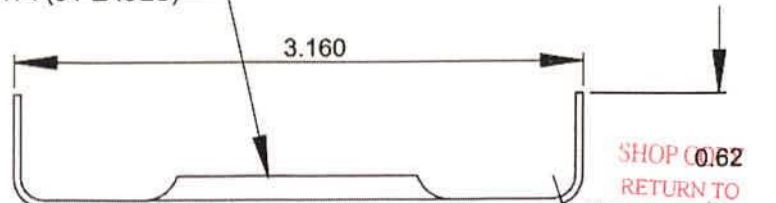
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DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

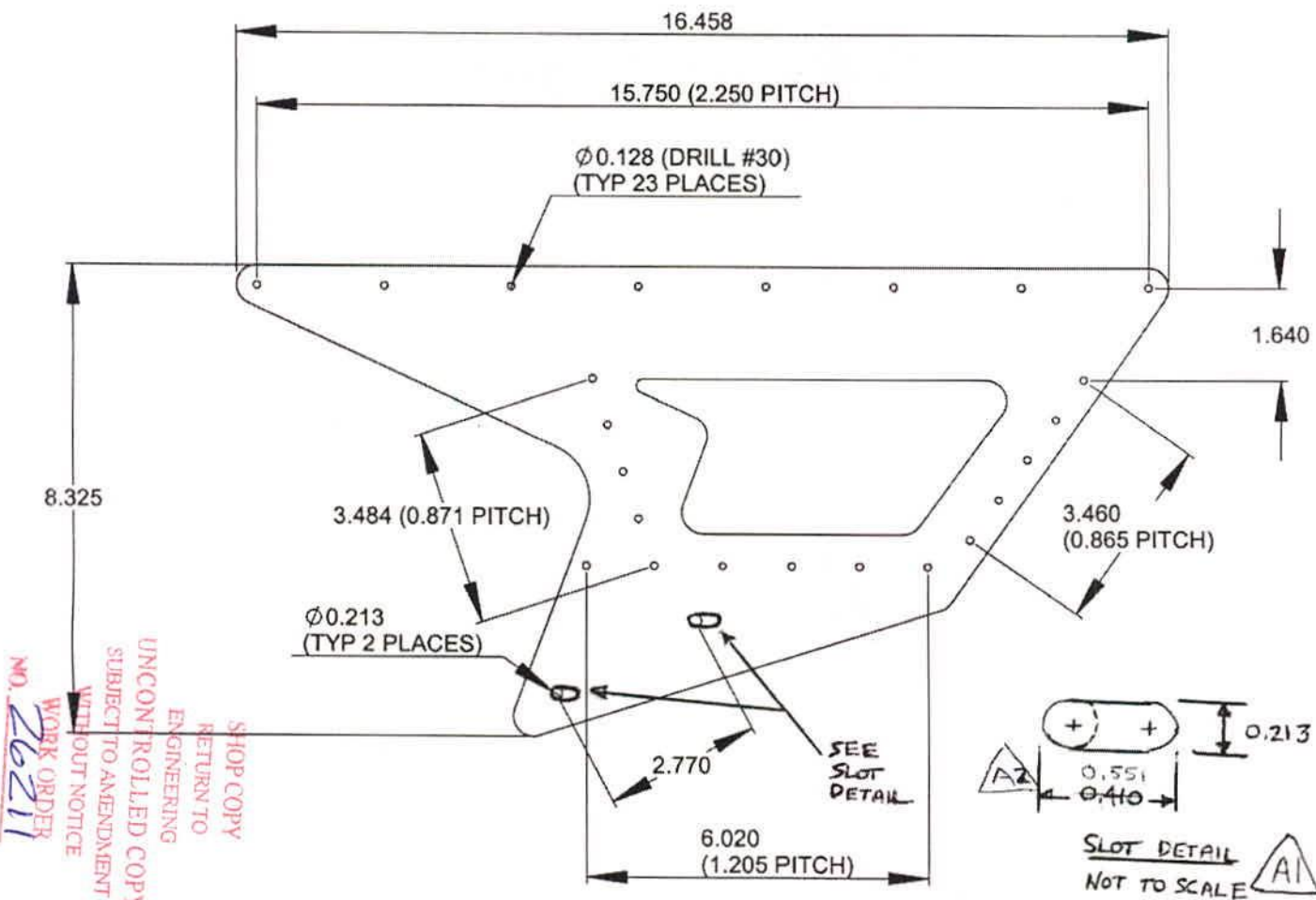
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CHECKED	<i>GP</i>	APPROVED	<i>GP</i>	DRAWING NO. D3065
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY	REV. A SHEET 4 OF 5
		SCALE	1:3	

RELEASED
02.09.20**D3065-5 STEP LEG**

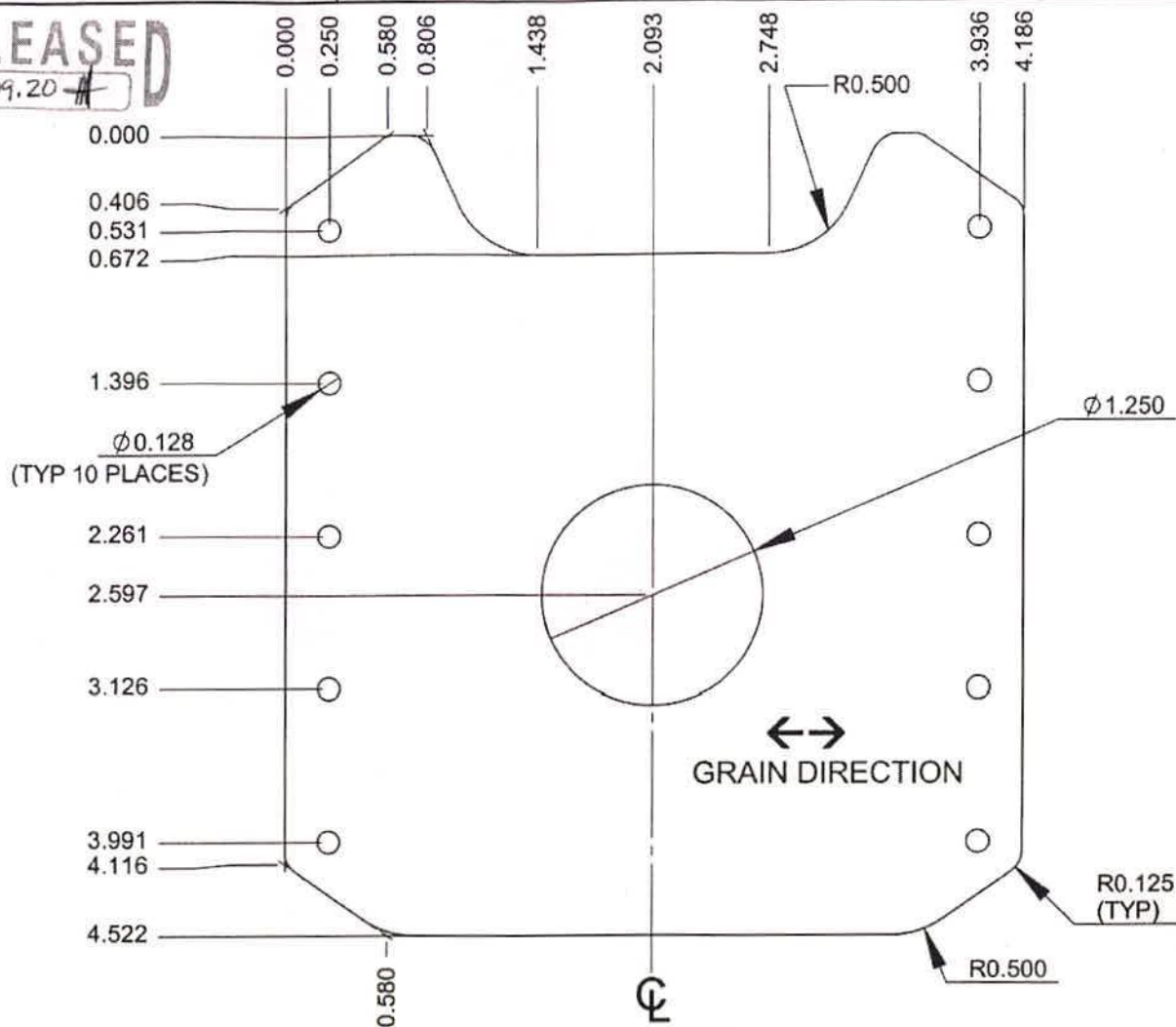
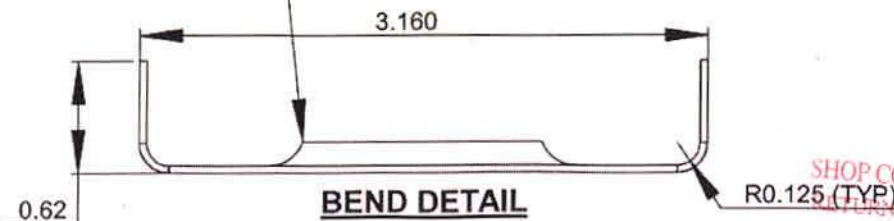
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *[Signature]***FLAT PATTERN**FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)**BEND DETAIL****D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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